

Date: Thursday, 10/25/2007 10:12:42 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASS'Y
Job Number : 35371	
Estimate Number : 12525	
P.O. Number : <u>N/A</u>	Part Number : D3531041
This Issue : 10/25/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3531 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 34804	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 11/10/2007
Checked & Approved By : <u>[Signature]</u>	Qty: <u>9</u> Um: Each
Comment : Est Rev: A New Issue 07-09-24 EC verified DD	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D35311	BRACKET
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 BRACKET  
 Batch: B35378 mf

2.0	D35313	BRACKET FRONT PLATE
-----	--------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 BRACKET FRONT PLATE  
 Batch: B35379 mf

3.0	MS20470AD44	Rivet, Universal Head
-----	-------------	-----------------------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)  
 Rivet, Universal Head  
m105125 mf 07-11-05

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Assemble as per dwg D3531  
mf 07-11-05 (710) (9)

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP  
U H1109 (x2)

6.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING  
 Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3  
FL 07/11/12 (9)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/11/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-11-06	4.	Two parts had each with a rivet that was <del>correct</del> installed wrong. RC Human error.	LB 07-11-08 Q51042	Put 2 rivets in MS 20470 AD 5-6 # B 2421 <del>Change</del>	MF 07-11-05		LB 07-11-08 Q51042	
		Install larger rivets						

NOTE: Date & initial all entries

Date: Thursday, 10/25/2007 10:12:42 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASS'Y

Job Number: 35371

Part Number: D3531041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(9X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-J 07/14/13

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57230

Ce 7/14/13 (9)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(9)

Comment: FINAL INSPECTION/W/O RELEASE

Dot 11/14

Job Completion



4 07.11.13

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

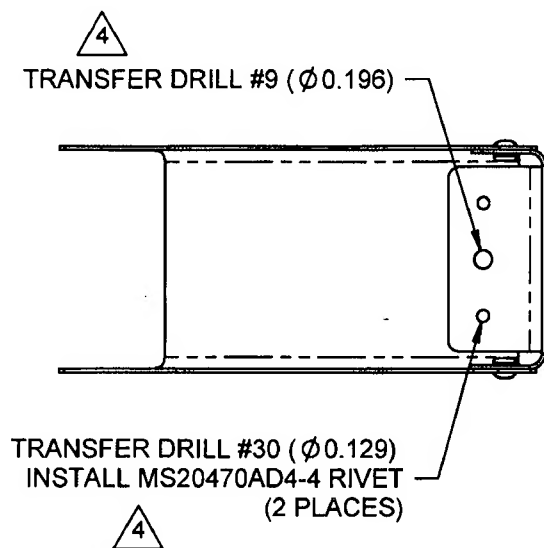
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

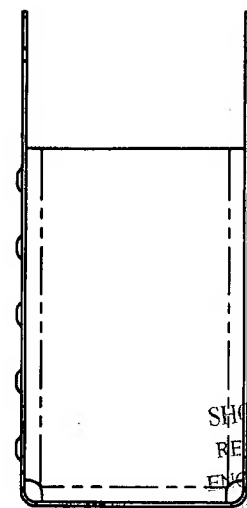
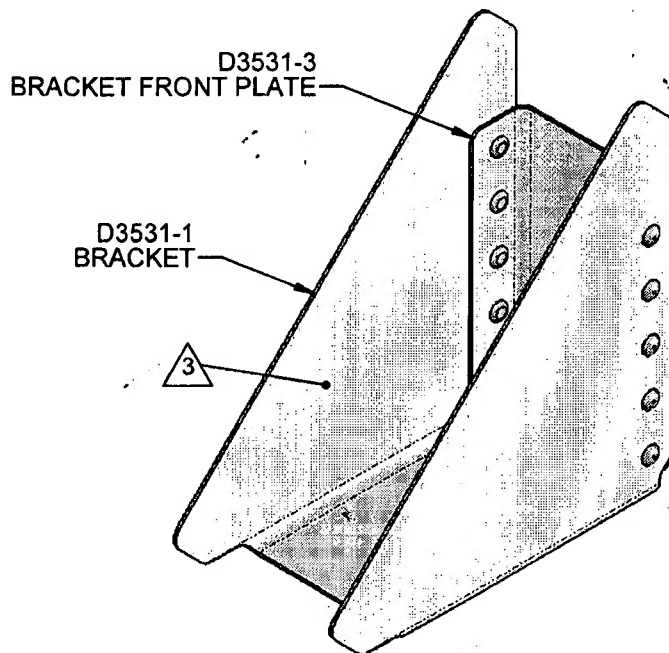
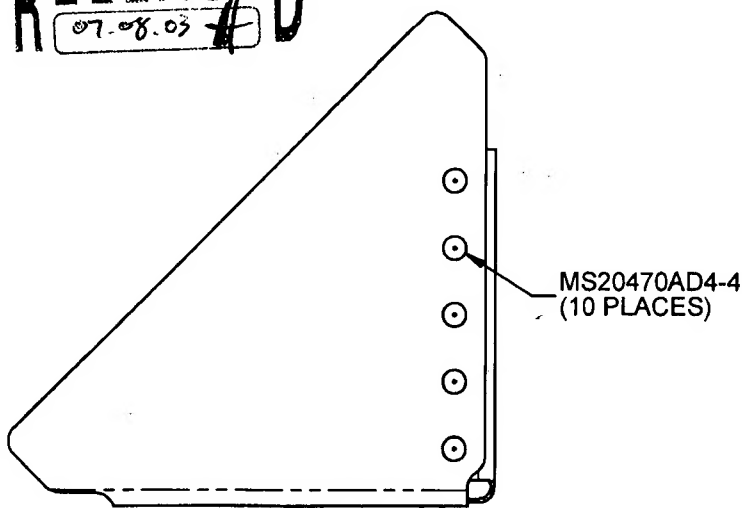
**NOTE:** Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3531	REV. A SHEET 1 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SCALE 1:2
REV A	DATE 07.06.19	DESCRIPTION NEW ISSUE	



RELEASED  
07.08.03



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35371

### D3531-041 BRACKET ASSEMBLY

#### NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK  
SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING  
WHITE MARKER ON INSIDE OF BRACKET  
ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET  
THROUGH D3531-3 BRACKET FRONT PLATE  
BEFORE FINISHING

#### PARTS LIST

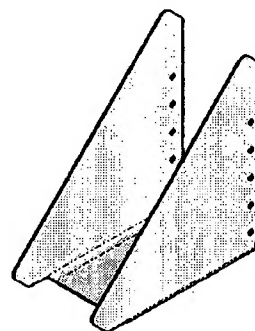
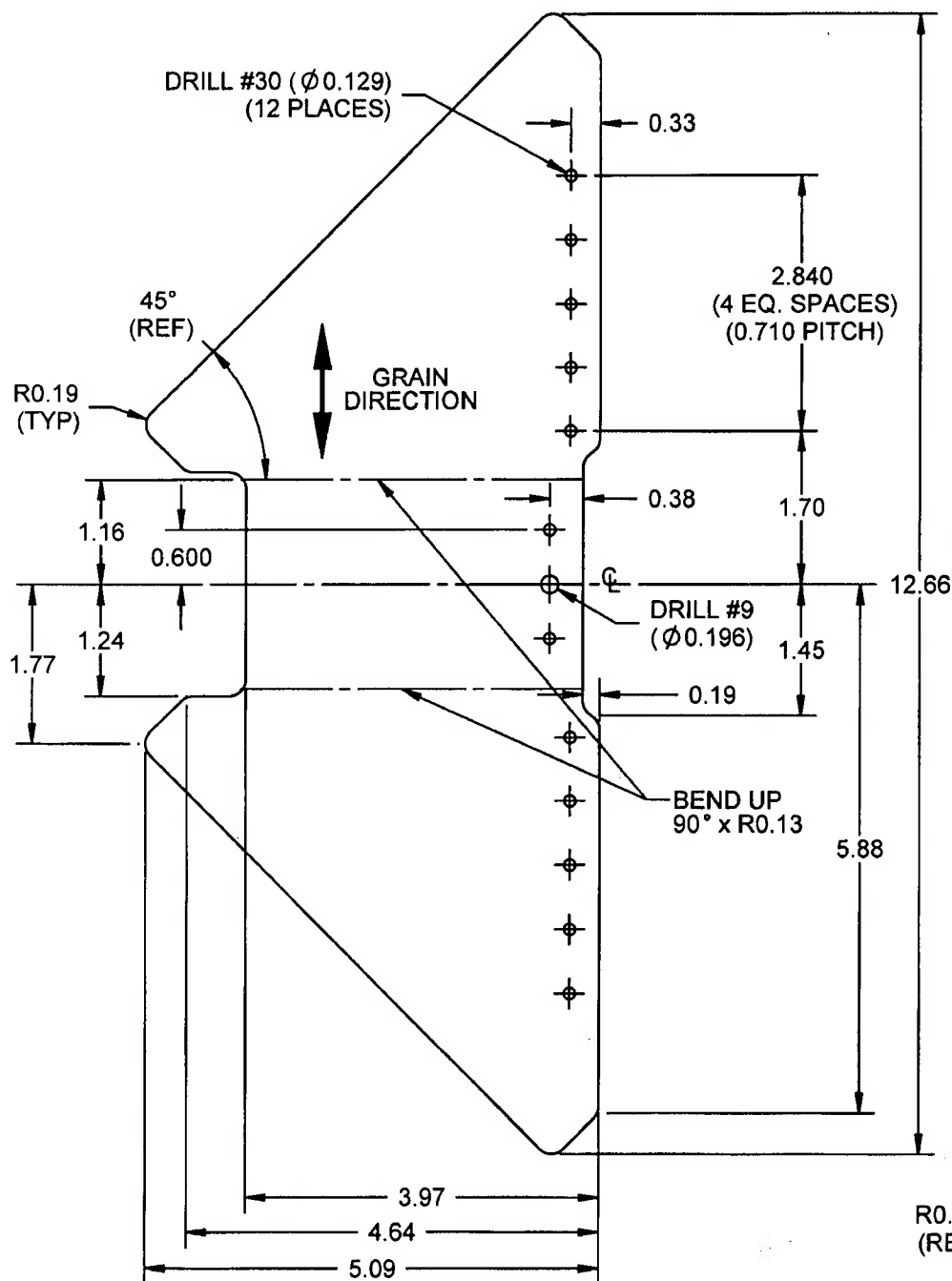
QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

COPYRIGHT © 2007 BY DART AEROSPACE LTD

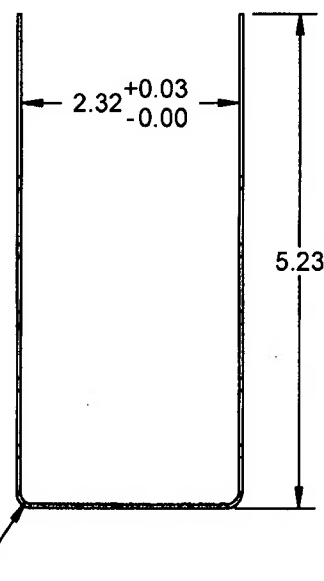
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>CE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3531</b>	REV. A SHEET 2 OF 3
DATE <b>07.06.19</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:2



**RELEASED**  
07-08-03



### D3531-1F FLAT PATTERN

#### NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$

### D3531-1 BRACKET

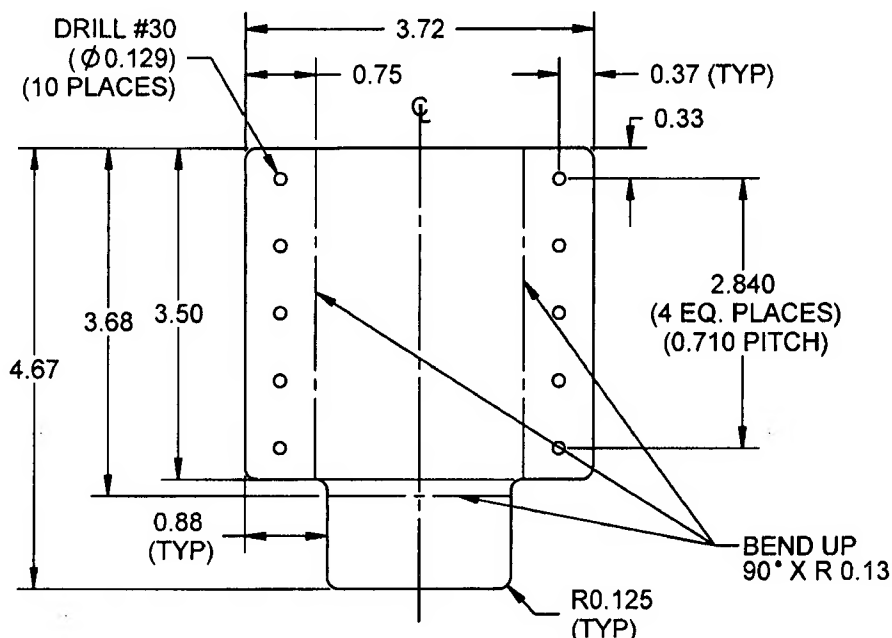
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **35371**

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

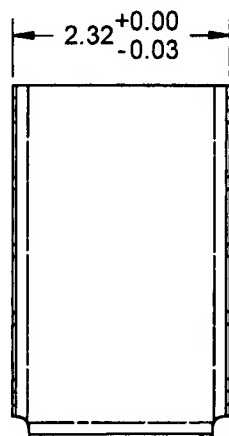
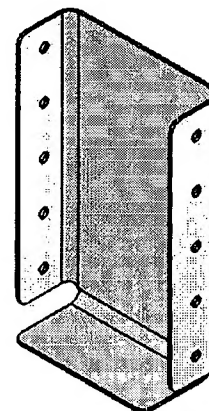


DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <b>CE</b>	APPROVED <b>#</b>	DRAWING NO. <b>D3531</b>
DATE <b>07.06.19</b>	TITLE <b>BRACKET ASSEMBLY</b>	REV. A SHEET 3 OF 3 SCALE 1:2

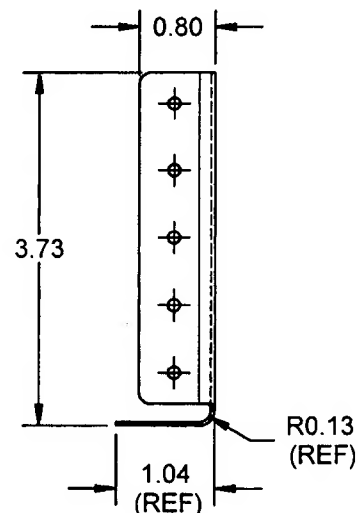


**D3531-3F FLAT PATTERN**

**RELEASED**  
07.08.03 **#**



**D3531-3 BRACKET FRONT PLATE**



**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **35371**

**COPYRIGHT © 2007 BY DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.